

Work Order ID 126207

Monday, November 03, 2014 8:22:17 AM

126207

Page 1

Item ID: D3650-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 11/3/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/3/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *11-11-03* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3650	Rev E
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100	FLOW WATER JET	0.00							
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100

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3650Dwg Rev: 6 Prog Rev: 6 2-Deburr if necessary

304 0018"

(6)

11/11/06

DAS
23
9-89

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110

QC

Memo

Quality Control

(6)

11/11/06

DAS
23
9-89

120	QC8- Inspect parts - second check	0.00							
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120

QC

Memo

Quality Control

(6)

DAS
38
9-89

NOV 10 2014

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

DAS
30
9-89

6

DAS
38
9-89

vllalr

Brake NC

Form as per Dwg D3650

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

6

NOV 12 2014

150

150

Packaging

Packaging

Identify as per dwg & Stock Location GA

Memo

0.00

0.00

DAS
86
9-89

6

NOV 13 2014

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Page 3

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Revision ID:

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Item Name: Angle

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5

Cust Item ID:

Required Date: 11/3/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14/11/17
MF
14-11-14

Picklist Print

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Page 1

Work Order ID: 126207

126207

Parent Item: D3650-9

D3650-9

Parent Item Name: Angle

Start Date: 11/3/2014

Required Date: 11/3/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA

Purchased

No

110

sf

270.6890

0.051

1

**

M304S26GA

304/316 0.018 SHEET

D-14/11/06
DAS
23
9-89

Location

Loc Qty

Loc Code

MAT020

270.689

122753

26

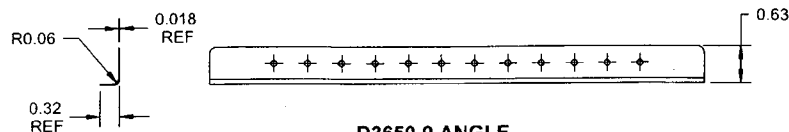
123135

54.689

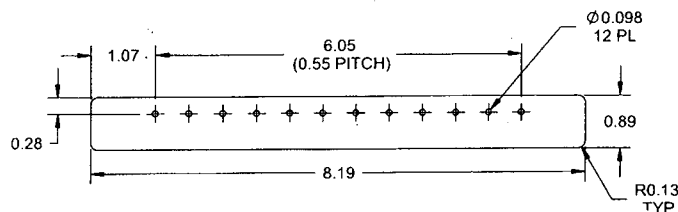
m130650

190

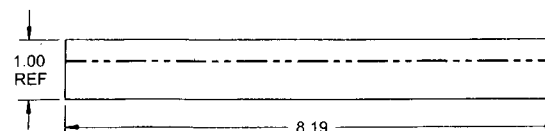
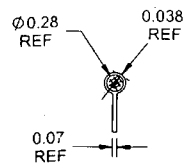
.4123



D3650-9 ANGLE
(MAKE FROM D3650-9F)



D3650-9F ANGLE (FLAT PATTERN)



D3650-7-8.19 SEAL

- NOTES:**
- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.05 lb
 - 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

SHOP COPY
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 126207 MLC

14-11-03

- D3650-9F**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.05 lb

RELEASED
2012-10-09

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.	RP	D3650	SHEET 8 OF 8
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	TOP PANEL ASSEMBLY	NTS
DATE	12.10.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	